



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D135-751-011
Job Sheet 200954



Part No: D135-751-011

Job Qty: 1 pcs

Part Name: Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/19/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 10/21/19

Description: SIOP

Type: Stock

Note: DWG DSI 9661 REV A, D3507 REV D IPP Rev:A 44353 New Issue JLM IPP Rev:B 06-12-18 As per Rev B JLM IPP Rev:C 07-12-11 ECN 1036 as per revB DD IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC verf DD IPP Rev E 10.02.22 per PAR 09-043 EC verified: DD IPP Rev:F 10.06.09 remove seq110 DD verf:EC IPP Rev G 10.09.17 added D3507-1-bent EC verified:DD IPP REV:H 13.12.11 ECN13-619/ CHG002 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Skidtubes - 1	1 pcs	10/21/19		0.00	0.80	Skidtubes - 1 - B4B		
							Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		
							Skidtubes - 4 - B4B		
							Skidtubes - 5 - B4B		
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
140	QC 5	1 pcs	10/21/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
150	Handfinish - 1-1 Chemical-B4B	1 pcs	10/21/19		0.00	0.33	Handfinish - 1 - 1 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
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Container No: S216977



Part: D135-751-011

Job No: 200954

Serial No/Batch: S216977

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SR017096E 18/10/17, TC, LoA RDIMS

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9/19/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

					Handfinish - 1 - 2 - B4B	SEP 26 2019
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
160 QC 7	1 pcs	10/21/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	

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						QC 7 - 9	
						QC 7 - 68	
						QC 7 - 50	
						QC 7 - 67	
						QC 7 - 40	
						QC 7 - 24	
						QC 7 - 43	
						QC 7 - 61	
						QC 7 - 81	
						QC 7 - 76	
170 Skidtubes - 2 - B4B	1 pcs	10/21/19	0.00	1.00		Skidtubes - 1 - B4B	LD
						Skidtubes - 2 - B4B	
						Skidtubes - 3 - B4B	
						Skidtubes - 4 - B4B	
						Skidtubes - 5 - B4B	BE
						Skidtubes - 6 - B4B	
						Skidtubes - 7 - B4B	
180 QC 10	1 pcs	10/21/19	0.00	0.00		QC 10 - 10	
						QC 10 - 18	
						QC 10 - 24	
						QC 10 - 43	
						QC 10 - 50	
						QC 10 - 58	
						QC 10 - 9	
185 Handfinish - 6-1- Touch Up- B4B	1 pcs	10/21/19	0.00	0.10		Handfinish - 6 - 1 - B4B	ML 14-10-10
						Handfinish - 6 - 2 - B4B	
						Handfinish - 6 - 3 - B4B	
						Handfinish - 6 - 4 - B4B	
						Handfinish - 6 - 5 - B4B	
						Handfinish - 6 - 6 - B4B	
						Handfinish - 6 - 7 - B4B	
						Handfinish - 6 - 8 - B4B	
						Handfinish - 6 - 9 - B4B	
						Handfinish - 6 - 10 - B4B	
						Handfinish - 6 - 11 - B4B	
						Handfinish - 6 - 12 - B4B	
						Handfinish - 6 - 13 - B4B	
						Handfinish - 6 - 14 - B4B	
						Handfinish - 6 - 15 - B4B	
						Handfinish - 6 - 16 - B4B	
						Handfinish - 6 - 17 - B4B	
						Handfinish - 6 - 18 - B4B	
						Handfinish - 6 - 19 - B4B	
						Handfinish - 6 - 20 -	

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187 QC 7	1 pcs	10/21/19	0.00 0.00	B4B	
				Handfinish - 6 - 21 - B4B	
				Handfinish - 6 - 22 - B4B	
				QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	
190 Skidtubes - 3 - B4B	1 pcs	10/21/19	0.00 0.77 1.07	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
200 QC 5	1 pcs	10/21/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	

210 Handfinish - 2-1 Pressure-B4B	1 pcs	10/21/19	0.00 0.08	QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	★ OCT 16 2019
220 Spray Paint - 2 - B4B	1 pcs	10/21/19	0.00 0.25	Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	DAS
				Spray Paint - 1 - B4B	, 41 OCT 16 2019
				Spray Paint - 2 - B4B	989
				Spray Paint - 3 - B4B	
225 QC 14	1 pcs	10/21/19	0.00 0.00	Spray Paint - 4 - B4B	
				QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	BEB 19-10-17
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
260 Handfinish - 4-1-Assembly-B4B	1 pcs	10/21/19	0.00 0.74	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	BEB 19-10-17
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
270 QC 5	1 pcs	10/21/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	

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					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	OCT 21 2019
					QC 5 - 61	DAS 40 9-89
					QC 5 - 81	
280	Packaging 1-1 - Pick Kit - B4B	1 ✓ pcs	10/21/19	0.00 0.00	Packaging 1 - 1 - B4B ✓	
					Packaging 1 - 2 - B4B	
					Packaging 1 - 3 - B4B	
					Packaging 1 - 4 - B4B	
					Packaging 1 - 5 - B4B	
					Packaging 1 - 6 - B4B	
					Packaging 1 - 7 - B4B	
					Packaging 1 - 8 - B4B	
					Packaging 1 - 9 - B4B	
					Packaging 1 - 10 - B4B	
					Packaging 1 - 11 - B4B	
					Packaging 1 - 12 - B4B	
					Packaging 1 - 13 - B4B	
					Packaging 1 - 14 - B4B	
					Packaging 1 - 15 - B4B	
					Packaging 1 - 16 - B4B	
					Packaging 1 - 17 - B4B	
					Packaging 1 - 18 - B4B	
					Packaging 1 - 19 - B4B	
					Packaging 1 - 20 - B4B	
					Packaging 1 - 21 - B4B	
					Packaging 1 - 22 - B4B	
					Packaging 1 - 23 - B4B	
					Packaging 1 - 24 - B4B	DAS 78 9-89
					Packaging 1 - 25 - B4B	
					Packaging 1 - 26 - B4B	
					Packaging 1 - 27 - B4B	
					Packaging 1 - 28 - B4B	
					Packaging 1 - 29 - B4B	
					Packaging 1 - 30 - B4B	
					Packaging 1 - 31 - B4B	
					Packaging 1 - 32 - B4B	
					Packaging 1 - 33 - B4B	
					Packaging 1 - 34 - B4B	
					Packaging 1 - 35 - B4B	
					Packaging 1 - 36 - B4B	
290	QC 4	1 pcs	10/21/19	0.00 0.00	QC 4 - 28	
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
					QC 4 - 68	
					QC 4 - 72	

300 Packaging 3-1 - Stock - B4B	1 pcs	10/21/19	0.00 0.00	QC 4 - 74	DAS 78	OCT 2 2 2019
				QC 4 - 75	9-89	
				Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B	DAS 78	
				Packaging 3 - 26 - B4B	9-89	
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
305 DC - 1 - B4B	1 pcs	10/21/19	0.00 0.00	DC - 1 - B4B	DAS 21	OCT 2 2 2019
				DC - 2 - B4B	9-89	
310 QC 21 - FG	1 pcs	10/21/19	0.00 0.00	QC 21 - FG - 21	DAS 21	
				QC 21 - FG - 70		OCT 2 2 2019
				QC 21 - FG - 53		

Part Op 120 - 1-Cut Aft end as per dwg D3507 3-Drill Aft & Fwd Cap holes using DT8678 & DT8901 4-Locate DT8870 & Drill Descriptions: Ground wire hole on top of Tube. 6-Locate DT8870 with #30 cleco in Ground wire hole ,then Pilot Drill all X-Bolt holes using #30" drill. ****DO NOT OPEN AFT CAP HOLES***** 7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES. 8-Open six rear wearplate holes using DT8892. Open all wearplate holes to 0.297" 9-Open ground wire hole .297" section E-E 10-Open Aft & Fwd Cap holes using .208" drill. 11-Bore out aft end of tube as per Dwg D3507 & Detail "B". 12- Section G-G holes must be laid out manually, open to #30. 13-Deburr holes.

140 - (QC5- Inspect part completeness to step on W/O)

160 - (QC7-Inspect Chemical Conversion Coat)

170 - 1-Open X-Bolt holes to .375" (1 Places) & .500"(2Places) as per Dwg D3507. and section G-G to .750" (2 places) 2-Counter Sink X-BOLT holes as per Dwg D3507 3-Deburr and blow out chips from inside of tube. 4-Bond web as per Dwg D3507 & QSI 015 start time : _____ end time: _____ 5-Weld x-bolt spacers as per Dwg D3507 and Detail C-C & D-D and G-G 7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B 8-Deburr Rivet holes.

180 - (QC10- Inspect visual per QSI004- ground welds)

185 - (Touch up alodine) RE-ALODINE ONLY

187 - (QC7-Inspect Chemical Conversion Coat)

190 - 1-Rivet D3506-1/-3 as per Dwg D3507.

200 - (QC5- Inspect part completeness to step on W/O)

210 - Touch-up alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

220 - (Spray Paint / NDT Room) 1- Apply Primer as per QSI 005 4.2.1.3.3 and dwg A/R Primer
 Batch: 5200277 2- Paint two coats of White paint as per QSI 005 4.2 and dwg A/R Paint
 Batch: 5213125

225 - (QC14- Inspect Spray Paint)

260 - 1- Install Wearplate & Ground Wire inserts as per Dwg D3507. 1-Inspect for Foreign objects 2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B" 3-Install Wearplates as per Dwg D3507 , Note:Install (1) Bolt and (1) washer on Ground Wire insert on top of tube Do not Install Screws where indicated on Dwg(Note #6) 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube 5- Wing Walk as per Dwg D3507 and QSI 005 4.4 Batch: _____

270 - (QC5- Inspect part completeness to step on W/O)

280 - (Pick Kit)

290 - (QC4- 100% Inspect kits for completeness)

300 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D135-751-011 PPP Rev: _____

305 - Photocopy bluefile & type labels per PPP D135-751-011 CHG002

310 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3507-1-BENT	Skidtube Assembly EC135	1 pcs (1 ea)	120-Skidtubes - 1	5166842
D3504-1	Crossbolt Spacer	2 pcs (2 ea)	170-Skidtubes - 2 - B4B	5146029
D3504-3	Crossbolt Spacer	1 pcs (1 ea)	170-Skidtubes - 2 - B4B	5167825
D3504-5	Crossbolt Spacer	2 pcs (2 ea)	170-Skidtubes - 2 - B4B	5091959
D3505-1	Web	1 pcs (1 ea)	170-Skidtubes - 2 - B4B	5154525
D3506-1	Doubler	4 pcs (4 ea)	190-Skidtubes - 3 - B4B	5146088
D3506-3	Doubler	2 pcs (2 ea)	190-Skidtubes - 3 - B4B	5154482
MS20601-AD4W3	Rivet	12 Ea (12 ea)	190-Skidtubes - 3 - B4B	5214552
ALS4-1032-225	Rivnut	1 Ea (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5192155
ALS7-1032-130	Rivnut	38 Ea (38 ea)	260-Handfinish - 4-1-Assembly-B4B	5190021
AN3C4A	Bolt	31 Ea (31 ea)	260-Handfinish - 4-1-Assembly-B4B	5218780
AN3C5A	Bolt	2 Ea (2 ea)	260-Handfinish - 4-1-Assembly-B4B	5216249
AN526C1032R10	Screw	2 Ea (2 ea)	260-Handfinish - 4-1-Assembly-B4B	5166981
D2965	Cap	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5166570
D2965-3	Cap	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5166571
D3492-1	Plug	4 pcs (4 ea)	260-Handfinish - 4-1-Assembly-B4B	5204549
D3492-3	Plug	4 pcs (4 ea)	260-Handfinish - 4-1-Assembly-B4B	5215332
D3492-7	Plug	2 pcs (2 ea)	260-Handfinish - 4-1-Assembly-B4B	5148611
D4918-047	Wearplate Aft	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5153202
D4918-1	Wearplate Fwd	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5220080
D4918-3	Wearplate Center Fwd	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5170023
D4918-5	Wearplate Center Aft	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5170026
NAS1149C0332R	Washer (AN960C10L)	33 Ea (33 ea)	260-Handfinish - 4-1-Assembly-B4B	5218154
NAS1611-007	O-Ring	2 Ea (2 ea)	260-Handfinish - 4-1-Assembly-B4B	F103697
NAS1611-010	O-Ring	4 Ea (4 ea)	260-Handfinish - 4-1-Assembly-B4B	5057658
NAS1611-013	O-Ring	4 Ea (4 ea)	260-Handfinish - 4-1-Assembly-B4B	5217822
AN3C4A	Bolt	8 Ea (8 ea) ✓	280-Packaging 1-1 - Pick Kit - B4B	5090636 ✓
D3512-041	Wearplate	2 pcs (2 ea) ✓	280-Packaging 1-1 - Pick Kit - B4B	5220936 ✓
NAS1149C0332R	Washer (AN960C10L)	8 Ea (8 ea) ✓	280-Packaging 1-1 - Pick Kit - B4B	5211548 ✓

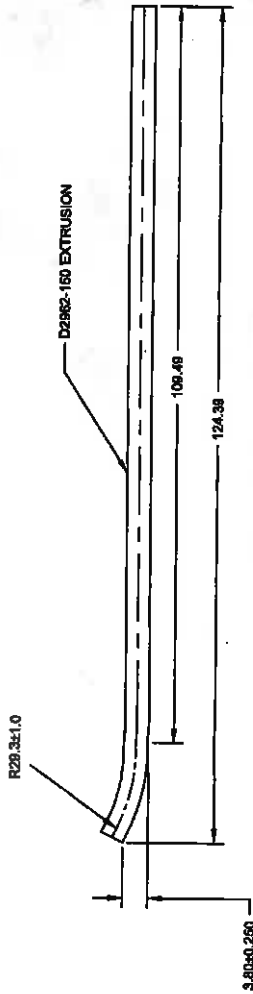
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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-Skidtubes - 1	D3507-1-BENT	1	10	0
	D3504-1	2	120	0
170-Skidtubes - 2 - B4B	D3504-3	1	103	0
	D3504-5	2	6	0
190-Skidtubes - 3 - B4B	D3505-1	1	10	0
	D3506-1	4	13	0
260-Handfinish - 4-1-Assembly-B4B	D3506-3	2	16	0
	MS20601-AD4W3	12	333	0
	ALS4-1032-225	1	1,872	0
	ALS7-1032-130	38	1,652	0
	AN3C4A	31	584	0
	AN3C5A	2	680	0
	AN526C1032R10	2	53	0
	D2965	1	52	0
	D2965-3	1	45	0
	D3492-1	4	92	0
	D3492-3	4	50	0
	D3492-7	2	14	0
	D4918-047	1	4	0
	D4918-1	1	0	0
	D4918-3	1	4	0
	D4918-5	1	4	0
	NAS1149C0332R	33	2,897	0
	NAS1611-007	2	232	0
	NAS1611-010	4	131	0
	NAS1611-013	4	128	0
280-Packaging 1-1 - Pick Kit - B4B	AN3C4A	8	584	0
	D3512-041	2	0	0
	NAS1149C0332R	8	2,897	0
Part Specifications				
Specifications could not be found.				

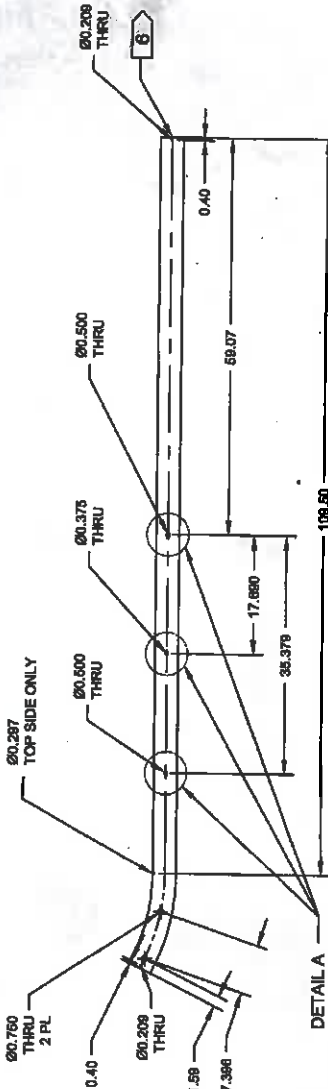
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Qty	Part Number	Description
1	D2907-041	SKIDTUBE ASSEMBLY
1	D2902-150	EXTRUSION
1	D2906	CAP
1	D2906-3	CAP
4	D3402-041	PLUG ASSEMBLY
4	D3402-043	PLUG ASSEMBLY
2	D3402-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3506-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D4816-1	WEARPLATE
1	D4816-3	WEARPLATE
1	D4816-5	WEARPLATE
1	D4816-007	WEARPLATE
38	AE15-1032-130	INSERT
1	AE15-1032-225	INSERT
31	AN5C4A	BOLT
2	AN5C8A	BOLT
2	AN526C-1032-10	SCREW
35	AN560C-10L	WASHER
12	MS20570D4W3	RIVET

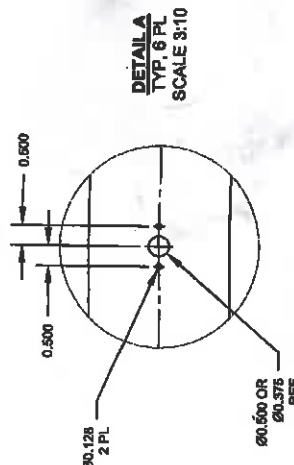
- GENERAL NOTES:**
- 1) MATERIAL: NA
 - 2) FINISH: PMS-1000 CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING STANDARD PRIME (REF: 4.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2. OPTIONAL: POWDER COAT WHITE (REF: 4.2.1.1) PER DART QSI 005 4.3. BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTERLINE PER DART QSI 005 4.4 (OPTIONAL)
 - 3) TOLERANCES: PER DART QSI 019 UNLESS OTHERWISE NOTED
 - 4) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.008 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART BN PER DART QSI 044 & 4 (VIBRATING STYLUS) ON I.D. OF TUBE.
 - 7) WEIGHT: 24.1 LB (FROM IN-0135-751)
 - 8) DRILLING TO BE DONE PER DART QSI 004
 - 9) INSERTS TO BE DRILLED TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBING. NON-STRUCTURAL SHAPLEX-241/281 ADHESIVE PER DART QSI 016 AFTER BENDING
 - 10) USE DART DRILL TEMPLATE D78868 TO LOCATE AND DRILL Ø0.287 HOLES (8 PLACES) FOR WEARSHOE INSERTS. INSTALL AE15-1032-130 PER SECTION C-4 (8 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SHAPLEX-241/281.
 - 11) DO NOT INSTALL AN5C4A BOLTS AND AN560C10L WASHERS IN INDICATED LOCATIONS



D3507-1 BENDING/CUTTING DETAIL



D3507-1 DRILLING DETAIL



DETAIL A
TYP. 6 PL
SCALE 3:10

D	REMOVE D3506-X GASKETS, D4816-X WAS D3508-X REVISE FINISH TO ADD PAINT AS THE PREFERRED FINISH, REVISED NOTES	DW	13.08.30
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.08.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DW		
DRAWN	DW		
CHECKED	DW		
MFG. APPR.	D3507		
APPROVED			
DE APPR.			
DATE	13.08.30		
DART AEROSPACE USA, INC KENT, WA			
DRAWING NO. REV. D			
SHEET 1 OF 2			
TITLE EC 135 SKIDTUBE SCALE NTS			
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RELEASED
2013-12-10

200954 MLS
19-09-19

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS		QTY Affected :		MRB (QSI042)	
Date : _____		Sequence #: _____		Cross tube Small Fab Finishing		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging		Engineering Water Jet Supplier Quality	
Description Work Order Deviation		Disposition							
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY							
		Pressure/Forced Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____		Contamination Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
Completed By								Lead hand / Supervisor	
QC / QA Coordinator									

5.0 PARTS LIST

Item	Qty -041	Qty -043	Qty -101	Part Number	Description
	X			D135-751-011	SKIDTUBE INSTALLATION
	1	X		D135-751-041	REPLACEMENT SKIDTUBE
			X	D135-751-043	WEARPLATE KIT
			X	D135-751-101	SKIDTUBE EXTENSION KIT
1		1		D3507-041	SKIDTUBE ASSEMBLY
2	4			**BRS8-98/48SZ-M8-W2	CLAMP
3	8			**LN9038-08032	SCREW
4		1		*D2965	CAP
5		1		*D2965-3	CAP
6		2		***AELS-1032-130	INSERT
7		2		***AELS-1032-225	INSERT
8		2		*AN3C5A	BOLT
9		2		*AN960C10L	WASHER
10		2		*AN526C1032-10	SCREW
20A		1	1	*D3508-1	WEARPLATE
20B		1	1	*D3558-1	GASKET
21A		1	1	*D3508-3	WEARPLATE
21B		1	1	*D3558-3	GASKET
22A		1	1	*D3508-5	WEARPLATE
22B		1	1	*D3558-5	GASKET
23A		1	1	*D3508-7	WEARPLATE
23B		1	1	*D3558-7	GASKET
24		38		*AELS-1032-130	INSERT
25		30	38	*AN3C4A	BOLT
26		30	38	*AN960C10L	WASHER
27			2	D3512-1	WEARPLATE
30		1		*AELS-1032-225	INSERT
31		1		*AN3C4A	BOLT
32		1		*AN960C10L	WASHER
40		4		*D3492-041	PLUG ASSEMBLY
41		4		***NAS1611-010	O-RING
42		2		*D3492-047	PLUG ASSEMBLY
43		2		***NAS1611-007	O-RING
44		4		*D3506-1	DOUBLER
45		8		*MS20601AD4W3	RIVET
46		2		*D3506-3	DOUBLER
47		4		*MS20601AD4W3	RIVET
48		4		*D3492-043	PLUG ASSEMBLY
49		4		***NAS1611-013	O-RING
50			1	D3510-041	INSERT ASSEMBLY
51			2	***AELS-1032-130	INSERT
52			6	***AELS-1032-225	INSERT
53			2	***ALS4-428-165	INSERT
54			2	AN4C7A	BOLT
55			2	AN960C416L	WASHER
56			2	AN3C4A	BOLT
57			8	AN3C7A	BOLT
58			10	AN960C10L	WASHER

* PART IS INCLUDED WITH D3507-041 SKIDTUBE ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER, LISTED AS REFERENCE ONLY

*** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

PAGE 1 OF 1

[illegible]